

ABSTRACT

5 A tool T such as a drill, a reamer or an end mill,
formed with a through hole extending along an axis O is
mounted to a tool holder 10. A pressurized gas, at 1.5 to
5 MPa, is supplied to the through hole by way of the tool
holder 10, and deep-hole machining is carried out while
the pressurized gas or a machining liquid in mist form is
ejected from the forward end of the tool T.